Dart Aerospace Ltd. Wednesday, 5/23/2007 3:24:13 PM Date User: Kim Johnston **Process Sheet Drawing Name** : STRUT : CU-DAR001 Dart Helicopters Services Customer Job Number : 32462 **Estimate Number** : 10282 AI4 : D2565107 Part Number P.O. Number S.O. No. : NIA D2565 REV E : 5/23/2007 **Drawing Number** This Issue : N/A Prsht Rev. Project Number : SMALL /MED FAB First Issue **Drawing Revision** : 27648 Material Previous Run Qty: : 5/29/2007 Each **Due Date** 10 Um: Written By Checked & Approved By : Est:F Added dwg Rev.C1 NG Comment 02.04.16 **Additional Product** Job Number: Description: Seq. #: Machine Or Operation: M304TR0750W049 304 RD Tube .750 x .049W 1.0 Comment: Qty.: 1.1751 f(s)/Unit Total: 11.7506 f(s) Material: 304/316 SS tubing 0.750" Dia. x 0.049" wall Batch No: (M304TR0750W049) NC BRAKE 2.0 BRAKE NO Comment: BRAKE NC 07-05-28 10 Punch as per Dwg D2565 using DT 8313 SMALL FAB SMALL & MEDIUM FAB RESOURCE 1 3.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr QC5 INSPECT WORK TO CURRENT STEP 4.0 29 Comment: INSPECT WORK TO CURRENT STEP POWDER COATING POWDER COATING 5.0 m 103 141 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 6.0 QC3

Comment: INSPECT POWDER COAT

| Dart | Aeros | pace | Ltd |
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| W/O: | | WORK ORDER CHANGES | | | | | | | |
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| DATE | STEP | | PROCEDURE CHANGE | | | | Approval Chief Eng / Prod Mgr Approv QC Inspec | | |
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| Part No: | _ PAR #: | Fault Category: | NCR: Yes No E | DQA: | Date: | <u>_</u> (|
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| | | Description of NC | | Corrective Action Section B | | Verification | Approval | Approval |
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NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:24:13 PM

User: Kim Johnston Process Sheet

Customer: CU-DAR001 Dart Helicopters Services Drawing Name: STRUT

Job Number: 32462 Part Number: D2565107

Job Number:

QC21

8.0

Seq. #: Machine Or Operation: Description :

7.0 PACKAGING 1 PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: St. 257

| Comment: PACKAGING RESOURCE #1

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion C207/06/04

Dart Aerospace Ltd

| W/O: | | | WORK ORDER | CHANGES | | | | |
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| DATE | STEP | | PROCEDURE CHANGE | Ву | Date | Qty | Approval Chief Eng / Prod Mgr | Approva QC Inspecto |
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| Part No | : | PAR #: _ | Fault Category: | NCR: Ye | s No DQ | A: | Date: | |
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| | | Description of NC | | Corrective Action Section B | | Verification | Approval Chief Eng | Annroyal |
| DATE | STEP | Section A | Initial Chief Eng | Action Description Chief Eng | Sign & Date | Section C | | Approval QC Inspector |
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NOTE: Date & initial all entries





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| CHEC | KED M_ | APPROVED | DRAWING NO. REV. E |
| | <u> </u> | 774 | D2565 SHEET 1 OF 1 |
| DATE | | | TITLE SCALE |
| 04.0 | 5.05 | | STRUT 1:3 |
| Α | | 96.05.03 | NEW ISSUE |
| В | | 97.03.15 | CORRECT D2565-111 DIM. A |
| С | | 98.10.05 | UPDATED MATERIAL NOTE (TSR A603) |
| D | | 02.06.05 | ADD -3XX PARTS; ADD FINISH |
| E | | 04.05.05 | ADD D2565-401-411; RMV ANGLE D |



| | | A B |
|-------|------|--|
| | ÷ . | DIA 0.257 TO BE PUNCHED —// "C" DIA TO BE OPENED MANUALLY |
| PUNCH | ENDS | PER SPEC CONTROL DRAWING D2638 — |

| PART # | Α | <u> </u> | DIA C |
|-----------|-------|----------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | |
| D2565-109 | 12.31 | 11.51 | - |
| D2565-111 | 13.65 | 12.85 | ••• |
| | | | |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | |
| D2565-209 | | | |
| D2565-211 | 14.14 | 13.34 | |
| | | | |
| | 27.03 | | 0.316 |
| D2565-303 | | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | |
| D2565-309 | 20.17 | 19.37 | _ |
| D2565-311 | 16.30 | 15.50° | _ |
| | | | |
| D2565-401 | 18.29 | | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | _ |
| D2565-409 | 9.34 | 8.54 | _ |
| D2565-411 | 13.81 | 13.01 | |
| | | | |

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL (REF DART SPEC. M304TR0.750W0.049)

ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

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